

• Work Order ID 130922

130922

Page 1

March-26-15 1:29:22 PM

Item ID: D2484 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Locknut
 Start Date: 3/26/15 Start Qty: 24.00 *24*
 Required Date: 3/26/15 Req'd Qty: 24.00 *24*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: MJS Date: 15e3-27 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2484	Rev A								

100 PURCHASING 0.00
 100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 27963 Order per Dwg D2484 Material release note required
 me master P/W: 91343 A100

Q2 15/03/31 50

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached

50x 8015-042

120 QC5- Inspect part completeness to step 2 W/O 0.00
 120
 QC Memo 0.00
 Quality Control

(50)
 DAS 38 9-89
 APP 06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

415-47

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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

March-26-15 1:29:22 PM

130922

D2484

Required Date: 3/26/15

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2484P

Lock Nut

24 50x
50x SPK-047

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. A
CHECKED B W	APPROVED 	D2484	SHEET 1 OF 1
DATE	TITLE		SCALE
95:10:06	LOCK NUT		

SPECIFICATION CONTROL DRAWING



1/4-20 LOW PROFILE
NYLON LOCK NUT



OR

1/4-20 SERATED FLANGE
LOCK NUT



NO 130922 MVS
15-03-27
SHEETS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27963**

Purchase Order Date 3/31/2015

PO Print Date 3/31/2015

Page Number 1 of 4

Order From :

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Contact Name

Vendor Phone 330 995 5500

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	8568K186	Neoprene Rubber 60A Medium Hard	4/1/2015 Yes 4/1/2015		1.00 Each	\$102.55	\$102.55

Line Total: \$102.55

2	D2484P	Lock Nut	4/1/2015 Yes 4/1/2015		50.00 Each	\$0.38	\$19.15
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AS PER DWG D2484 REV. A
B130922

MCMASTER P/N: 91343A100

Line Total: \$19.15

Note:

3/31/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Deliver To Luc

Purchase Order
PO27963

Order Placed By
Chantal Lavoie

McMaster-Carr Number
1428983-01

Page 1 of 1

03/31/2015

Line	Product	Ordered	Shipped
1	8568K186 High-Strength Multipurpose Neoprene Rubber, 1/2" Thick, 12" X 24", 60A Durometer	1 Each	1
2	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10	5 Packs	5 ✓
3	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	8 Each	8 SP15-04-1
4	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25	2 Packs	2
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100	1 Pack	1
6	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick	40 Each	40
7	9198K16 Easy-to-Machine 303 Stainless Steel Rod, 5" Diameter, 3" Long	1 Each	1
8	19525T13 Nonmarking High-Temperature Caster, Swivel, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity Your Part Number: 71400-40	4 Each	4
9	19525T17 Nonmarking High-Temperature Caster, Rigid, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, Deliver To Luc Your Part Number: 71400-40	4 Each	4

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 26682794
Purchase Order: PO27963
Release:
McMaster-Carr Number: 1428983-01

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Ultimate Destination:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Shipped: 31-Mar-2015 FOB: ORIGIN
Shipper's Export Declaration (SED):
NO EEI 30.36

Intermediate Consignee:

Bill To:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Tax Number:

Forwarding Agent:

Billing
Attention:
Shipping Deliver To Luc
Attention:
Contact:

Line	Description	Qty & Unit	Unit Price	Extension
1	8568K186 High-Strength Multipurpose Neoprene Rubber, 1/2" Thick, 12" X 24", 60A Durometer Country of Origin: United States Schedule B #: 400821 ECCN #: EAR99 NLR	1 EA	\$102.55	\$102.55
2	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10 Country of Origin: Taiwan Schedule B #: 731816 ECCN #: EAR99 NLR	5 PK	\$3.83	\$19.15
3	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	8 EA	\$17.14	\$137.12
4	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25 Country of Origin: Taiwan Schedule B #: 731822 ECCN #: EAR99 NLR	2 PK	\$6.66	\$13.32

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

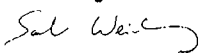
These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.

Shipping Weight (in kgs): 21 Number of Packages: 1

Package Dimensions:
64 X 33 X 34 CM = .071 CUBIC M

Invoice Amounts: Merchandise Amount: \$1,284.06
Total (In USD): \$1,284.06

Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days

Authorized Signature:  Date: 31-Mar-2015

Remit payment to: (by wire transfer)
Bank of America Illinois
231 S LaSalle
Chicago, IL 60697
ABA 071000039 Account 86666-02021
SWIFT BOFAUS3N
(by mail)
McMaster-Carr Supply Company
PO Box 7690
Chicago, IL 60680-7690 USA

Name: Sarah Weinberg Title: Operations Mgr.

Page 1 of 2

McMaster-Carr Supply Company
 200 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 26682794
 Purchase Order: PO27963
 Release:
 McMaster-Carr Number: 1428983-01

ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100 Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 PK	\$8.60	\$8.60
6	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Country of Origin: Peoples Republic of China Schedule B #: 848330 ECCN #: EAR99 NLR	40 EA	\$17.24	\$689.60
7	9198K16 Easy-to-Machine 303 Stainless Steel Rod, 5" Diameter, 3" Long Country of Origin: Sweden Schedule B #: 722211 ECCN #: EAR99 NLR	1 EA	\$154.08	\$154.08
8	19525T13 Nonmarking High-Temperature Caster, Swivel, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity 71400-40 Country of Origin: Peoples Republic of China Schedule B #: 871690 ECCN #: EAR99 NLR	4 EA	\$23.53	\$94.12
9	19525T17 Nonmarking High-Temperature Caster, Rigid, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, Deliver To Luc 71400-40 Country of Origin: Peoples Republic of China Schedule B #: 871690 ECCN #: EAR99 NLR	4 EA	\$16.38	\$65.52
	NOTE Tracking number(s) for this shipment: 633862298275			

Number of Packages: 1

Page 2 of 2